

Ship DEC. 16

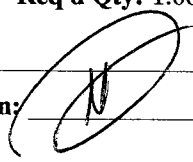
Work Order ID 139946

139946

Page 1

Tuesday, December 15, 2015 11:37:43 AM

Item ID: D139-799-033 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: OEM Maintenance Step Cable Replacement
Start Date: 12/15/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 12/16/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan:  Date: 12-15 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
IIN-D139-799	J								

100 0.00
100
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile &type labels per PPP D139-799-033
CHG002

MCS DEC 16 2015

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

DAS 28 9-89
DEC 15 2015

120 QC4- 100% Inspect kits for completeness 0.00
120
QC Memo 0.00
Quality Control

DAS 27 9-89
DEC 15 2015

QA Closed: Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other						
Date :		Step #:			QTY Effective :			MRB (QSI042) Approval			
Description Work Order Deviation					Disposition						
										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due					FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence						
					OTHER :						

Work Order ID 139946

139946

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Tuesday, December 15, 2015 11:37:43 AM

Item ID: D139-799-033 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: OEM Maintenance Step Cable Replacement
 Start Date: 12/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/16/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-033								
	Location: _____								
	PPP rev: _____								
	sold								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS

26

9-89

DAS

27

9-89

DEC 16 2015

MCS

DEC 16 2015

MCS

DEC 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 139946

139946

Parent Item: D139-799-033

D139-799-033

Parent Item Name: OEM Maintenance Step Cable Replacement

Start Date: 12/15/2015

Required Date: 12/16/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.05.26 chg001/ECN14-567 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5039-5 *D5039-5* Half Link		Manufactured	No				Each	8.0000		4			
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST144				8					
				137876				8		4			
D5039-3 *D5039-3* Master Link		Manufactured	No				Each	65.0000		8			
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST143				25					
				130293				25					
				ST155a				40					
				130476				40		8			
D5040-1 *D5040-1* Chain		Manufactured	No				Each	16.0000		4			
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST144				16					
				137877				16		4			
D5041-1 *D5041-1* Scuff Guard		Manufactured	No				Each	6.0000		4			
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST144				6					
				130295				6		4			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Qty -033	Qty -013	Part Number	Description
	X	D139-799-013	CARGO DOOR HINGE KIT
X		D139-799-033	OEM MAINTENANCE-STEP CABLE REPLACEMENT KIT
	1	D2585	MOUNTING CHANNEL
	1	D2586	DOOR LATCH
	1	D2621	LATCH PLATE
	1	D3552-23	DOOR PROP
	1	D3622-1	BALL STUD
	1	D3622-3	BALL STUD
	2	D4072-1	AIRFRAME HINGE
	2	D4072-3	AIRFRAME HINGE BACKING PLATE
	4	D4072-5	BUSHING
	2	D4073-1	DOOR HINGE
	2	D4073-3	DOOR HINGE BACKING PLATE
	1	D4074-1	BRACKET
	1	D4074-3	CHANNEL
	1	D4074-5	BACKING PLATE
	1	D4074-7	STRIKER PLATE
	1	D4519-1	RELAY BRACKET
	1	D4632-1	STRIKER PLATE
	1	D4632-2	STRIKER PLATE
	1	D4761-1	SHIM BLOCK
8		D5039-3	MASTER LINK
4		D5039-5	HALF LINK
4		D5040-1	CHAIN ASSEMBLY
4		D5041-1	SCUFF GUARD
	1	IN4007	DIODE
	4	AN507-1032R12	SCREW
	4	AN507-1032R15	SCREW
	1	M12883-41-19	RELAY BASE
	4	M39029/92-534	SOCKET CONTACT
	1	M83536/9-024M	RELAY
	8	MS21042L08	NUT (or MS21042-08)
	32	MS21042L3	NUT (or MS21042-3)
	1	MS21042L5	NUT (or MS21042-5)
	8	MS24694-S47	SCREW
	8	MS27039-0807	SCREW
	8	MS27039-1-10	SCREW
	2	MS27039-1-14	SCREW
	8	MS27039-1-16	SCREW
	1	MS27039-1-17	SCREW
	18	NAS1149D0363J	WASHER (or AN960JD10)
	1	NAS1149D0663J	WASHER (or AN960JD616)
	12	NAS1149D0332J	WASHER (or AN960JD10L)
	8	NAS1149DN832J	WASHER (or AN960JD8)
	4	NAS1515H-5L	WASHER

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Date: 15.07.20